

Work Order ID 142087

142087

U/R

Page 1

Wednesday, February 24, 2016 11:26:26 AM

Item ID: D412-664-403 Accept *N900040100* Setup Start *NS1*
 Revision ID: URF 15-561 Stop *NS2*
 Item Name: 412 Stainless Steel Aft Crosstubes - High
 Start Date: 2/24/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/11/2016 Req'd Qty: 1.00 *1* Customer:
 Reference: 4/08/2016

Approvals: Process Plan: MLS Date: FEB 24 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-443	AUR * 16/3/13								DAS 21 16-05-02 9-89
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-664-403		CHG001						
110	BENDING MACHINE - CROSSTUBES	0.00							
110									
CNC Bend 2	Memo	0.03							
CNC Alpha 160 Bender	Bend tube as per Dwg D412-664-443 using CNC bender program _____ and Folio FT _____								
	****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****								
127	QC15- Crosstube Dimensional Check	0.00							
127									
QC	Memo	0.00							
Quality Control	***MARK CUT LINES***								

DAS
27
9-89

JUL 22 2016

BL

16/03/29

4S DAS
18 32
89 9-89

MAR 29 2016

D412-664-403/142087

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
128		0.00							
128									
Crosstubes	Memo	0.01							
Crosstubes	CUT TUBE AT HEIGHT ON FAI SHEET								
	VERF HEIGHT <u>24.620</u> BY QC 15 LEVEL INSPECTOR <u>JTW</u>								
	VERF TWIST <u>0.012</u> BY QC15 LEVEL INSPECTOR <u>mm R</u>								
130		0.00							
130									
Crosstubes	Memo	0.03							
Crosstubes	1- Drill Tube as per Dwg D412-664-443 Using DT <u>8559</u> Drill Jigs, Set-up drill table as per QSI 010								
	2 -Deburr								
	3- Engrave Part # and Batch # as per Dwg D412-664-443								
	4-Remove all marks from tube within limits of D412-664-43 DWG.								

142087

Wednesday, February 24, 2016 11:26:26 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/24/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 3/11/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140 QC6- Inspect dimensions to drawing

0.00

140

0.00

QC

Memo

Quality Control

DAS
38
9-89

APR 04 2016

174 Outsource process - NDT per QSI038 4.1

0.00

174

3.00

Outsource2

Memo

Outsource process - NDT

ISSUE P/O TO ACCUREN: 31971

1 APR 11 2016 DAS 13 8-89

176 Receive & Inspect for Damage & Mat'l Certs

0.00

176

0.00

Packaging

Memo

Packaging

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Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
178	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
178									
QC	Memo	0.00							
Quality Control									APR 28 2016
180		0.00							DAS 41 9-89
180	SprayPaint								
SprayPaint	Memo	0.01							
Spray Painting	***USE AXALTA 230S PRE-TREATMENT AS PER QSI005*** AXALTA BATCH: <u>132474</u> 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: <u>134454</u> 2- MASK UNDERSIDE OF CROSSTUBE AS SHONE ON DWG BEFORE PAINTING 3 -Paint Outside of Tube as per Dart QSI 005 4.2 BATCH: <u>134341</u> 4- After painting remove masking and apply matte clear coat per QSI005 4.2 CLEAR BATCH: <u>133641</u>								16-4-25

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Wednesday, February 24, 2016 11:26:26 AM

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Required Date: 3/11/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Crosstubes	0.00							DAS 41 9-89
2000		0.01				1			16-7-20
Crosstubes	Memo								
Crosstubes	1- Install center support using scoth-weld DP460 per QSI 015, as per DWG. note 12. Install supports clamps using as per Dwg D412-644-443. Install clamp with rubber cushion as per DWG. note 13. ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG. A/R scoth-weld DP460 BATCH #: <u>132504</u> EXP DATE: <u>8/16</u> 2- **IF NOT ALREADY PRESENT ON CHAFFING SHEILD.** Apply a thin coat of proseal 890 per QSI 015 on inside concave surface of chafing shield and let cure per manufacturer's instructions. Install prosealed chafing shield onto crosstube by applying a thin coat of proseal 890 onto crosstube. Be sure to eliminate any air gaps. Install and torque clamps on chafing shield to 40-50 IN-LBS AS PER DWG. A/R Proseal 890 Batch: <u>135043</u> EXP DATE: <u>12/16</u> AFTER FINISH CURE TIME 24H START CURE TIME: <u>16-7-20</u> FINISH CURE TIME: <u>16-7-21</u> PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.								

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Wednesday, February 24, 2016 11:26:26 AM

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 Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00							
240	Packaging					DAS 27 9-89			
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPPD412-664-443								
	Location: _____								
	PPP Rev: _____								
250	QC21- Final Inspection - Work Order Release	0.00							
250						DAS 21 9-89			
QC	Memo	0.00							
Quality Control									

JUL 22 2016

JUL 25 2016

2m 16/07/22

Picklist Print

Page 1

Wednesday, February 24, 2016 11:26:31 AM

Work Order ID: 142087

142087

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-664-443TRN

Manufactured

No

110

Each

4.0000

1

1

D412-664-443TRN

Crosstube Turning Detail

Location

Loc Qty

Loc Code

LG003

4

139897

1

139898

1

139899

1

139900

1

D3595-063-530

Manufactured

No

200

Each

38.0000

2

2

D3595-063-530

Rubber Cushion 0.63" wide x 5.30" Long

Location

Loc Qty

Loc Code

FG

1

82656

1

LG051

1

132515

1

LG052

36

138921

36

D4909-1

Manufactured

No

200

Each

9.0000

1

1

D4909-1

Support

Location

Loc Qty

Loc Code

LG053

9

135507

5

140154

4

**

**

**

DAS
41
9-89

DAS
41
9-89

16/03/2016

16-7-20

16-7-20

Picklist Print

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Page 2

Work Order ID: 142087

142087

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

D4910-1 Manufactured No

200 Each 17.0000 2 2

DAS

D4910-1

41

Chaffing Shield

9-89

16-7-20

Location

Loc Qty

Loc Code

LG053

17

139520

8

2

141315

9

MS21920-26 Purchased No

200 Each 27.0000 4 4

DAS

MS21920-26

41

Clamp

9-89

16-7-20

Location

Loc Qty

Loc Code

LG057

27

M132045

1

M133234

2

M133483

4

M133577

20

4

MS21920-28 Purchased No

200 Each 92.0000 2 2

DAS

MS21920-28

41

Clamp

9-89

16-7-20

Location

Loc Qty

Loc Code

FG

1

105884

1

LG051

1

M132169

1

LG057

90

M130400

50

M133090

2

M134130

38

Picklist Print

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Work Order ID: 142087

142087

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-40A
AN6-40A
3/8-24 BOLT X 3" LONG

Purchased No

220 Each

66.0000

4 4

**

DAS
6
9-89

[Handwritten signature]

Location

Loc Qty

Loc Code

over005

24

M133316

24

ST333

42

M133769

42

220 Each

35.0000

2 2

**

DAS
6
9-89

[Handwritten signature]

AN6-41A
AN6-41A
Bolt

Purchased No

Location

Loc Qty

Loc Code

over005

25

M133577

25

ST286A

1

M129913

1

ST333

9

M131957

9

220 Each

0.0000

18 18

**

134360

[Handwritten signature]

AN960JD616

NAS1149D0663J

Purchased

No

AN960JD616
Washer

DAS
6
9-89
APR 30 2016

DAS
27
9-89

Picklist Print

Wednesday, February 24, 2016 11:26:31 AM

Work Order ID: 142087

142087

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

220

Each

208.0000

6

6

MS21042L6

Nut



Location

Loc Qty

Loc Code

ST007

100

m134055

100

ST303

108

m133134

5

m133932

3

m133938

50

m134257

50

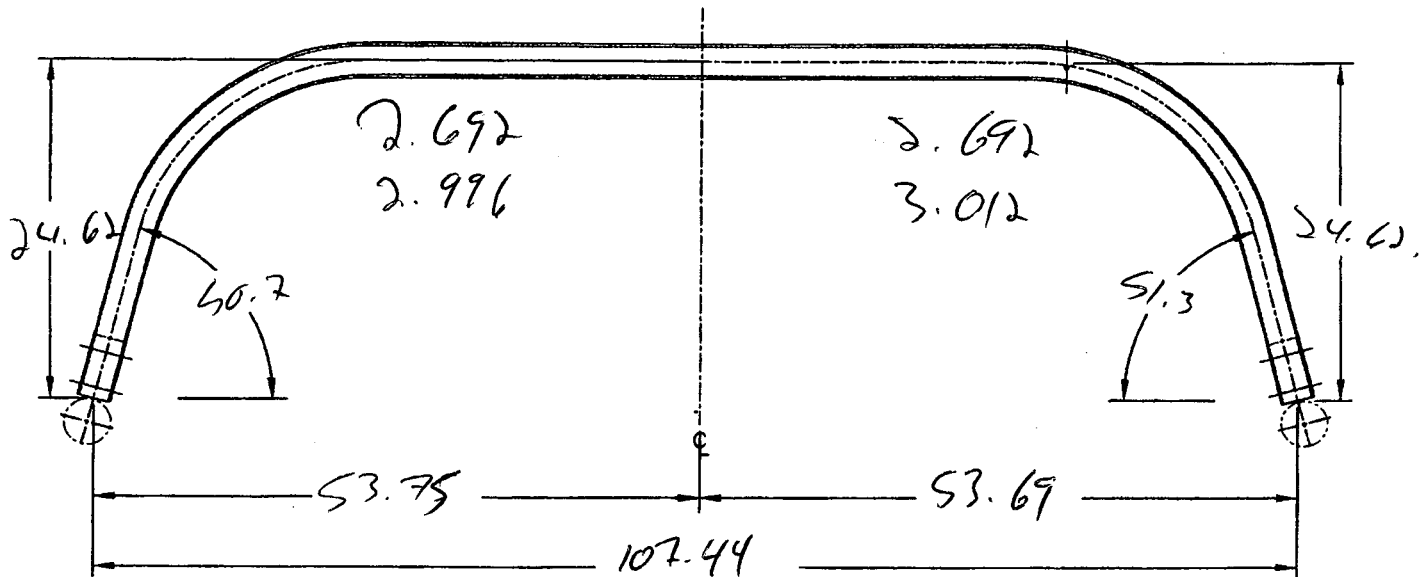
6 _____

AS 3 2016

DAS
27
9-89

DART AEROSPACE LTD		Work Order:	142087
Description: Crosstube High Aft (412)		Part Number:	D412-664-403
Inspection Dwg: D412-664-443 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	24.12	24.62
1/2 Span	53.56	53.82
Angle	49°	52°
Total Span	107.12	107.64
Bending Passes	8	--
Crushing	--	7%



	Side A	Side B
Bending Passes	4	7
Crushing	5.3%	5.6%
Comments		

QC15 Inspection		DAS
Date		38
		MAR 29 2016

Rev	Date	Change	Revised by	Approved
A	14.07.08	New Issue	KJ	up

Item	Qty -443	Part Number	Description
1	X	D412-664-443	CROSSTUBE ASSEMBLY (412 HI AFT)
2	1	D6020-132	CROSSTUBE MATERIAL (132" MIN. LENGTH)
3	2	D3595-063-530	RUBBER CUSHION
4	1	D4909-1	SUPPORT
5	2	D4910-1	CHAFING SHIELD
7	4	MS21920-26	CLAMP
8	2	MS21920-28	CLAMP
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
10	A/R	PROSEAL 890	SEALANT

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6020-132
FINISHED LENGTH = 130.10±0.060 (BEFORE BENDING/TRIMMING)
 - FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2, HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, REMOVE MASKING AND APPLY MATTE CLEAR COAT PER DART QSI 005 4.2
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - UNITS: INCHES UNLESS OTHERWISE NOTED.
 - BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - IDENTIFICATION: SCRIBE DART P/N "D412-664-443" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - WEIGHT: 90.2 lb AFTER MACHINING
88.7 lb FINISHED WEIGHT
 - PART IS SYMMETRIC ABOUT CENTERLINE.
 - EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- BENDING**
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7% (BASED ON O.D.) IN LOWER HALF OF R35 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
 - LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

ASSEMBLY

- INSTALL D4909-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015.
- INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D4909-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT.
- IF NOT ALREADY PRESENT ON CHAFING SHIELD, APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D4910-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- TORQUE CLAMPS ON D4909-1 SUPPORT 80 TO 100 IN-LB. TORQUE CLAMPS ON D4910-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVES HAVE CURED FOR 24 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142083 M15
16-08-24

UNDER REVIEW

UP 15/4/20
LRF 15-561

UNDER REVIEW

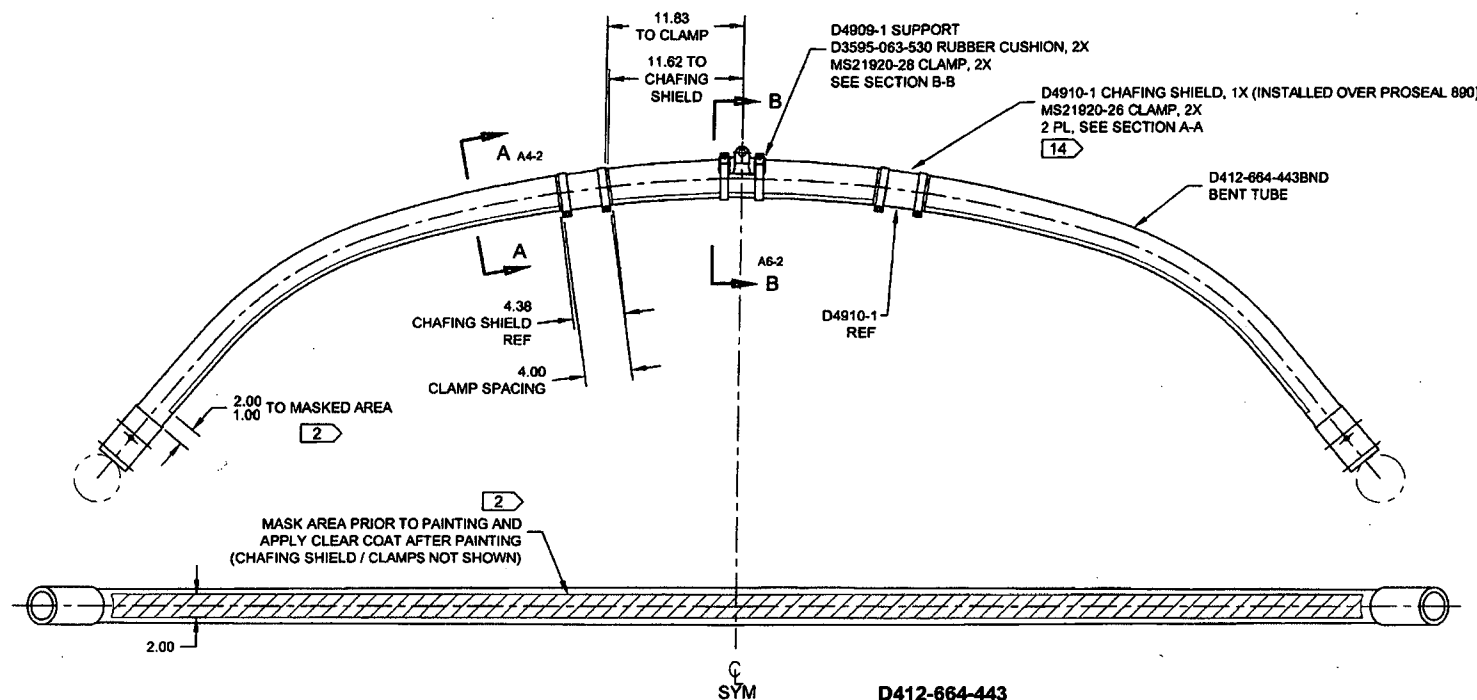
UP 17/10/20
LRF 17-691

RELEASED
2014-05-26

A	NEW ISSUE	CP	14.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

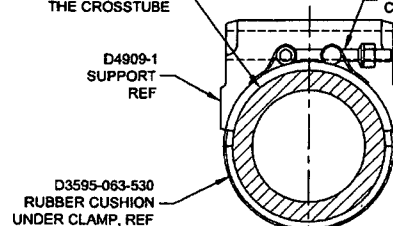
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D412-664-443	REV. A SHEET 1 OF 4
TITLE CROSSTUBE ASSY (412 HI AFT)	SCALE NTS

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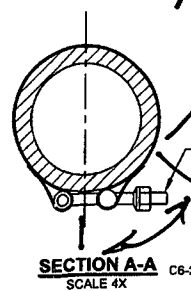
D412-664-443
ASSEMBLY DETAIL

12
APPLY 3M SCOTCH-WELD DP460
BETWEEN D4909-1 SUPPORT
AND THE CROSSTUBE



SECTION B-B D4-2
SCALE 4X

13 15
MS21920-28 CLAMP, REF



SECTION A-A
SCALE 4X

WRAP D4909-1
50 overlap
at this location
15

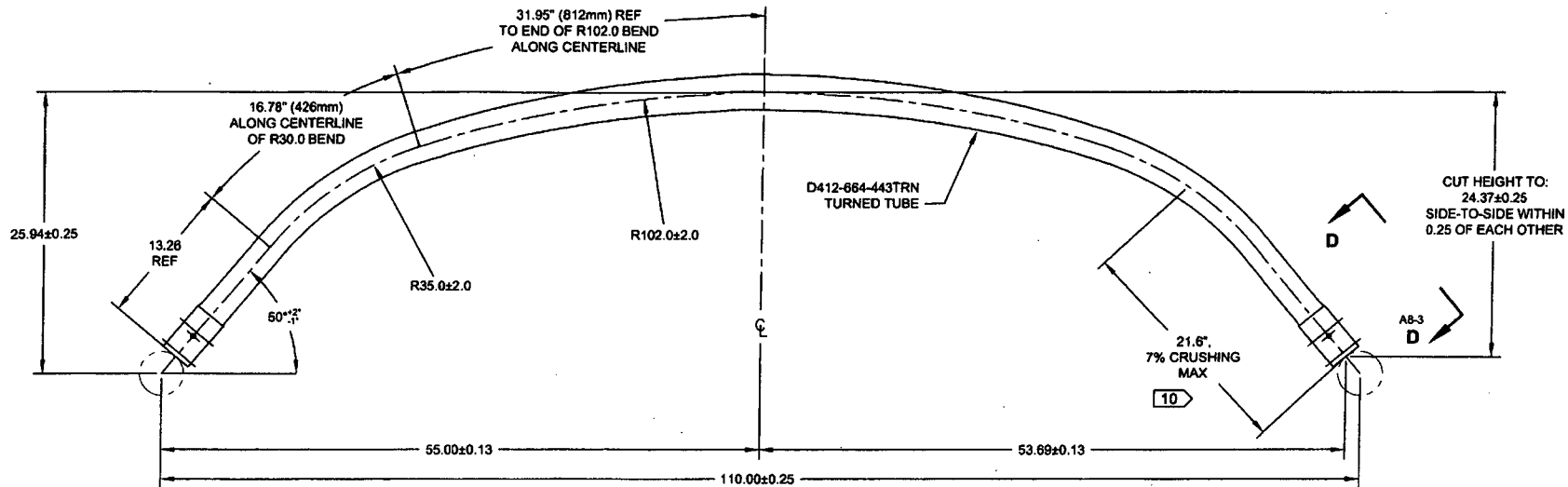
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CHECKED	9
MFG. APPR.	9
APPROVED	9
DE APPR.	9
DATE	14.04.01

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D412-664-443	REV. A SHEET 2 OF 4
TITLE CROSSTUBE ASSY (412 HI AFT)	SCALE NTS
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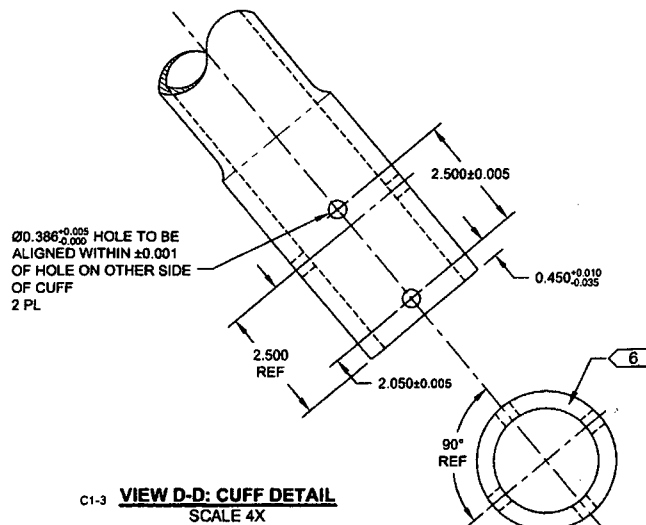
UNDER REVIEW
9/16/21

RELEASED
2014-05-26
WMD



D412-664-443BND
BENDING DETAIL

10



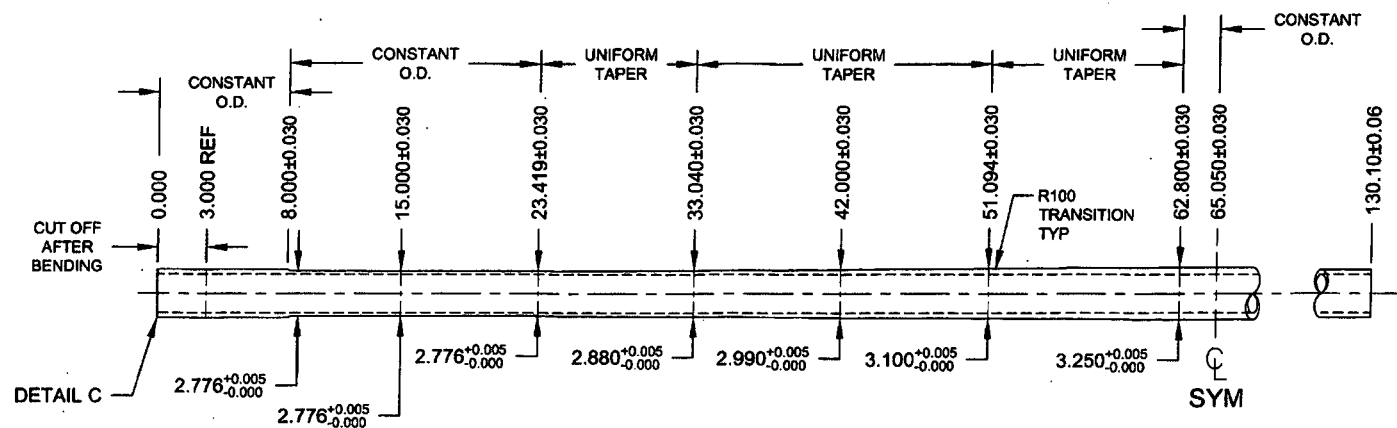
C1-3 **VIEW D-D: CUFF DETAIL**
SCALE 4X

OK
P. 11/14/14
UNDER REVIEW
11/17/14

UNDER REVIEW
P. 15/14/12

RELEASED
2014-05-26

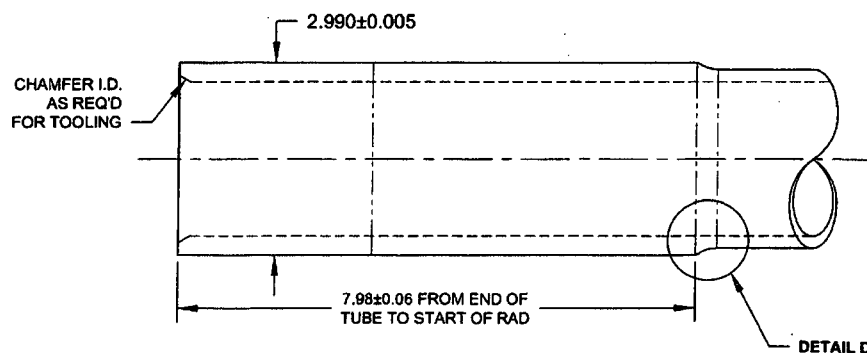
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DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.		D412-664-443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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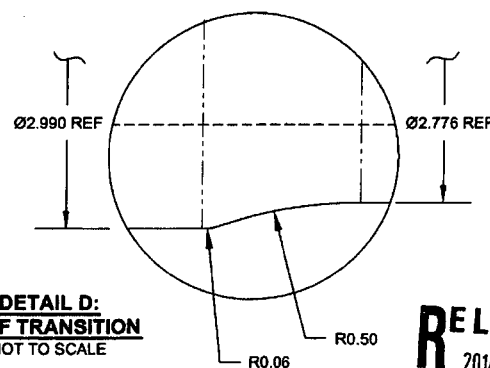
D412-664-443TRN
TURNING DETAIL

UNDER REVIEW

15/4/28



DETAIL C:
CUFF TRANSITION
SCALE 4X



DETAIL D:
CUFF TRANSITION
NOT TO SCALE

OK 15/4/28
UNDER REVIEW

RELEASED
2014-05-26

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. A
MFG. APPR.		D412-664-443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31971

Purchase Order Date 4/7/2016

PO Print Date 4/11/2016

Page Number 3 of 4

Order From :

VC-SKY001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

Contact Name

Vendor Phone

905-678-5636

Ship To Contact

Ship To Phone

Ship Via:

Delivered

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$135.00

6 142086

D412-664-403
CROSSTUBE

4/11/2016

1.00

\$135.00

\$135.00

Yes

4/11/2016

Line Total: \$135.00

7 142087

D412-664-403
CROSSTUBE

4/11/2016

1.00

\$135.00

\$135.00

Yes

4/11/2016

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

SP/6 curd

Line Total: \$135.00

8 143893

D412-664-403
CROSSTUBE

4/11/2016

1.00

\$135.00

\$135.00

Yes

4/11/2016

Note:

4/11/2016

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO27855	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO31971
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING seven (7) CROSSTUBES:

ID# D412-664-403 STAINLESS STEEL AFT CROSSTUBES-HIGH

- 1 WORK ORDER ID 142085 2-WORK ORDER ID 142086
3.WORK ORDER ID 142087 4-WORK ORDER ID 143893

ID# D412-664-203 AFT CROSSTUBES-HIGH

- 5 WORK ORDER ID 143853 6 WORK ORDER ID 143855
7 WORK ORDER ID 143856

8/16 eu-12

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-7) AS PER ASTM1417 M-13						11 APR 20/6	
NO APPARENT DEFECT FOUND							
PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO13923)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	
			D4S				
			33				
			948				

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: 11 APR 20/6
Name: CHRISTIAN BRIEN		